

Work Order ID 157016***157016***

Page 1

Wednesday, February 08, 2017 10:19:42 AM

Item ID: D4148-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stud Receiver, Lower

Start Date: 2/15/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/24/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: FEB 14 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4148	E

100	Cut blanks as per folio	0.00
-----	-------------------------	------

100

Bandsaw

Memo

0.07

Jeaspa Bandsaw

5.350" LONG

10	0		DAS 33 9-89 17/02/28
----	---	--	-------------------------------

110

0.05

110

HAAS 1

Memo

0.80

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA944 AND DWG

FOLIO REV: AADWG REV: E

DEBURR

10	1		DAS 45 9-89 17-3-1
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Pto →

			DAS 20 9-89 17-03-0
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DQA: Stut Date: 2017-04-08
 QA Closed: RAH Date: MAR 08 2017 **WORK ORDER NON-CONFORMANCE / UPDATE**



Work Order update only ☐

Work Order: <u>157016</u> Part No. <u>D4148-3</u> NCR No. <u>17-6311</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☒</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☒	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																									
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Description Work Order Deviation <u>Dimension .625" is at .590" and</u> <u>chanfer is at .090" instead of .060"</u> <u>R.C. part not position correct correctly</u> <u>in vise</u>				Disposition <u>Scrap and replace</u> <u>M 135861</u>				Completed By DAS 45 9-89 <u>17-3-1</u>																																																																																							
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Work Order ID 157016

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157016

Page 2

Item ID: D4148-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stud Receiver, Lower
Start Date: 2/15/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 2/24/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.02				10	1		DAS 45 9-89 17-3-1
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03				10	0		DAS 49 9-89 17/03/62
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>Storage</u> Memo	0.00 0.02				10	6		DAS 6 9-89 MAR 04 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.17							
Quality Control									

DAS
21
9-89
MAR 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, February 08, 2017 10:19:42 AM

Page 1

Work Order ID: 157016

157016

Parent Item: D4148-3

D4148-3

Parent Item Name: Stud Receiver, Lower

Start Date: 2/15/2017

Required Date: 2/24/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD IPP
REV:B 11.03.02 AS PER DWG REV.D DD VERF:EC IPP REV:C
13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X03.000		Purchased	No			100	f	7.1700	0.48	4.8		DAS 33 9-89	
M303B1 000X03 000										4.8		17/02/28	
303 BAR 1" X 3'													

Location	Loc Qty	Loc Code
MAT008	7.17	
M133610	0.42	
M135861	6.75	

4.5 + .458 = 4.958

4.958

DQA: _____ Date: _____



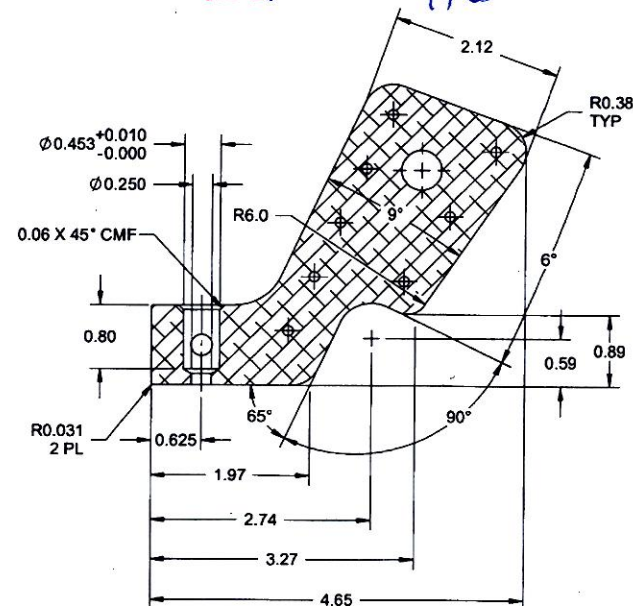
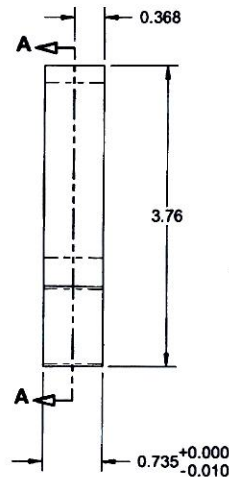
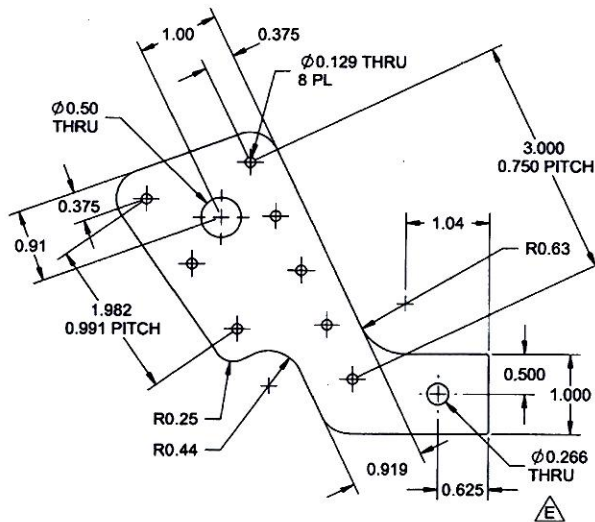
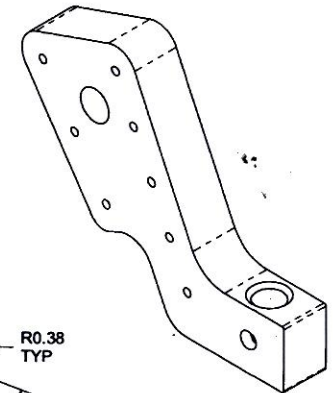
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~157-016~~ *170214*



D4148-3 STUD RECEIVER LOWER

SECTION A-A

RELEASED
2013-08-16

- NOTES:**
1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.51 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4148	REV. E
MFG. APPR.	<i>[Signature]</i>	TITLE FWD X-TUBE LUG ASSY	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	SCALE NTS	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	13.07.22	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	